

File: Friday, 30/05/2008 10:12:28 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABLE GUARD
Job Number	: 39592		
Estimate Number	: 12457		
P.O. Number	:	Part Number	: D29163
This Issue	: 30/05/2008 S.O. No. :	Drawing Number	: D2916 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 37554	Material	:
Written By	:	Due Date	: 10/06/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.5.30</u>		
Comment	: Est Rev:A New Issue 06-06-19 JLM Est Rev:B Now water jet 06-07-14 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.5775 sf(s)/Unit Total : 5.7750 sf(s)

UHMW 1" Black

batch: 108013 B 8-6-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2916

Dwg Rev: B B 8-6-5Prog Rev: B

10

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-6-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: M1080131- Mill as per Folio FA2916-3 Rev: A & Dwg D2916 Rev: B

2-Deburr per dwg D2916

M.A. / mg

08/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:28 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 39592

Part Number: D29163

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A.P.M.R. 08/06/22

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/06/25

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *207*

P 8/6/25 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



MF 08-06-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

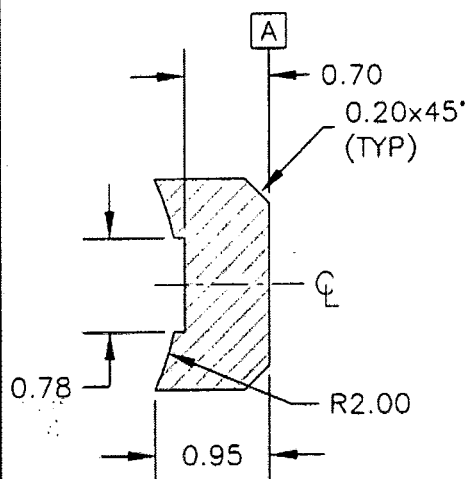
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

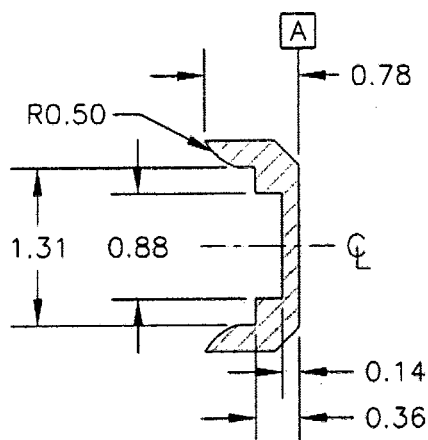
NOTE: Date & initial all entries



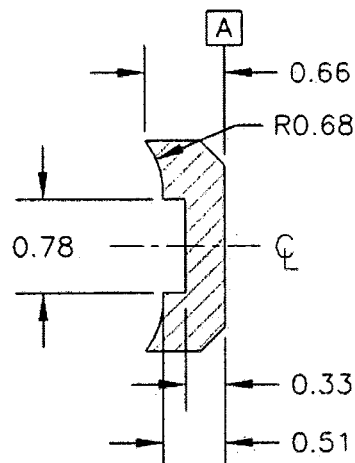
DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



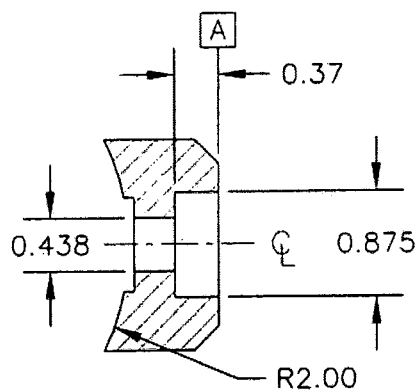
SECTION A-A
(SCALE 2:3)



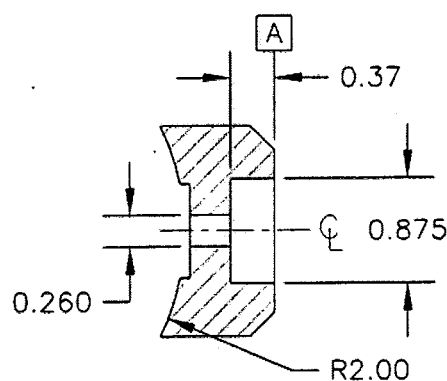
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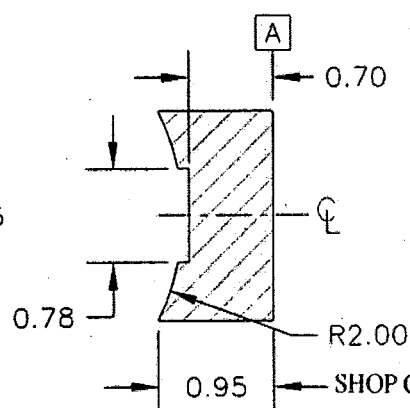
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(SCALE 2:3)



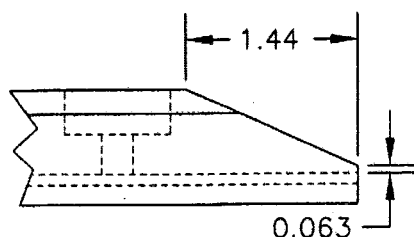
SECTION D-D
(SCALE 2:3)



SECTION E-E
(SCALE 2:3)

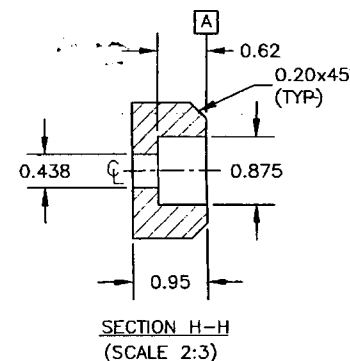
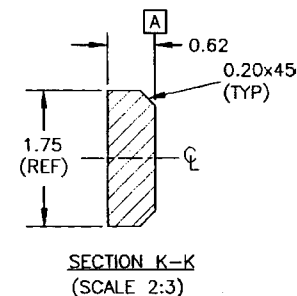
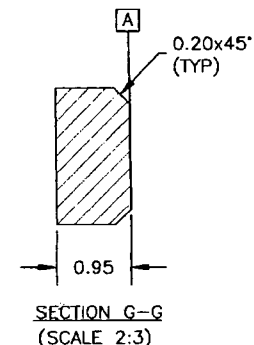
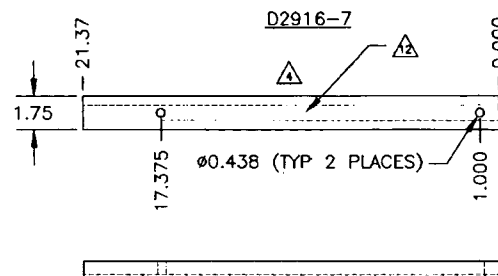
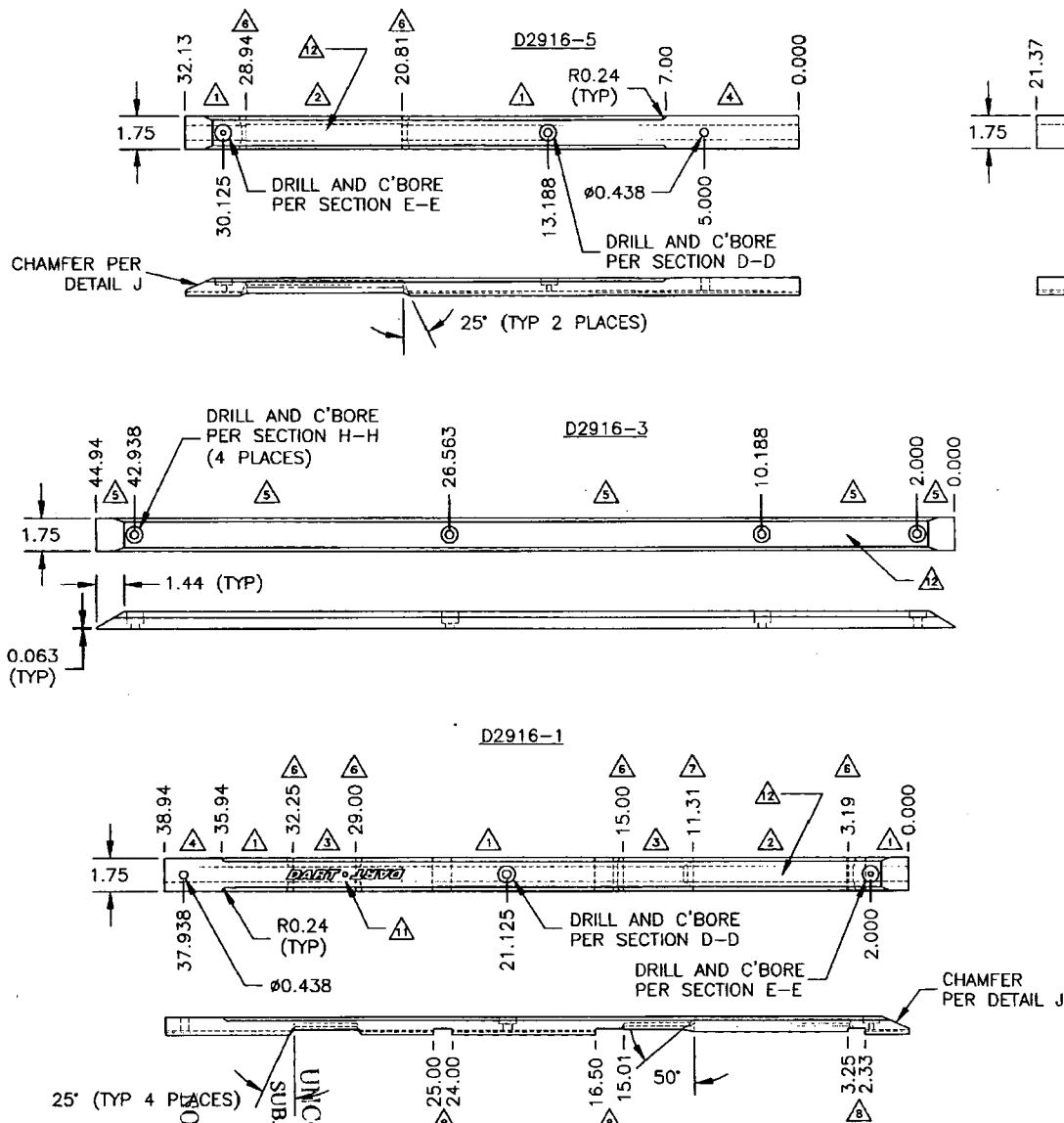


SECTION FIVE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39592



DETAIL J
(SCALE 2:3)

RELEASE
000.02.25 DS



- NOTES:
- 1) MACHINE CONSTANT SECTION A-A
 - 2) MACHINE CONSTANT SECTION B-B
 - 3) MACHINE CONSTANT SECTION C-C
 - 4) MACHINE CONSTANT SECTION F-F
 - 5) MACHINE CONSTANT SECTION G-G
 - 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
 - 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
 - 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
 - 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
 - 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
 - 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
 - 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
 - 13) ALL HOLES DRILLED ON CENTERLINES
 - 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 15) ALL DIMENSIONS ARE IN INCHES

RELEASED

DESIGN #	DRAWN BY	DART	DART AEROSPACE LTD
CHECKED #	APPROVED #	DRAWING NO.	REV. B
DATE	TITLE	D2916	SHEET 2 OF 2
00.02.24	CABLE GUARD		SCALE 1:6

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
29592